Dart Aerospace Ltd. Monday, 9/10/2007 1:27:40 PM Kim Johnston User: **Process Sheet** : LUG ASSEMBLY 206L/407 GHW LUG **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 34484 : 12923 **Estimate Number** : D2659UP : NIA Part Number P.O. Number S.O. No. : NA : D2659 REV A : 9/10/2007 **Drawing Number** This Issue : N/A Project Number Prsht Rev. : LARGE FAB ASSY Type **Drawing Revision** First Issue :NIA : 33780 Material Previous Run Due Date : 9/30/2007 Qty: 20 Um: Each Written By Checked & Approved By New Issue 07-07-04 JLM : Est Rev!A Comment **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: 34484A LUG 1.0 R29228A Comment: Sub-Component LUG D2657 B B32654 16X 34484B LUG BRACKET 2.0 Comment: Sub-Component LUG BRACKET D2658 B \$34484 A LARGE FABRICATION RESOURCE 1 3.0 Comment: LARGE FABRICATION RESOURCE 1 1-Weld as per Dwg D2659 using location Jig DT8484 A/RSteel Rod MI03794 4.0 QC9 VISUAL WELDING INSPECTION Comment: VISUAL WELDING INSPECTION INSPECT WORK TO CURRENT STEP 5.0 QC5 Comment: INSPECT WORK TO CURRENT STEP

6.0 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:





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W/O:		·		<b>WORK ORDI</b>	R CHANGES				
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Part No	:	PAR #:	Fault C	Category:	N		No DQA:		
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DATE	OTER	Description of NC		Corrective Action Section B			Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action	<b>Description</b> hief Eng	Sign & Date	ign &   Section C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Date:

Monday, 9/10/2007 1:27:40 PM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY 206L/407 GHW LUG

Job Number: 34484

Part Number: D2659UP

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



J7159.19

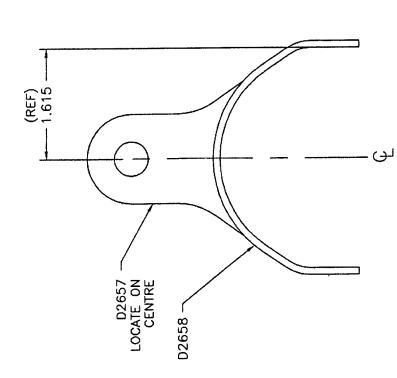
## **Dart Aerospace Ltd** W/O: **WORK ORDER CHANGES** Approval Chief Eng / Prod Mgr Approval QC Inspector DATE STEP PROCEDURE CHANGE Ву Date Qty Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_ Date: \_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

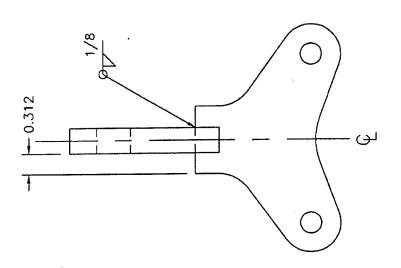
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		Description of NC		Corrective Action Section B	Verification	Annroyal	Annewal		
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NOTE: Date & initial all entries



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1 4	- (U	D2659	SHEET 1 OF.1
DATE		TITLE	SCALE
97.1	1.03	LUG ASSEMBLY	NTS
Α	97.11.03	NEW ISSUE	





D2659 LUG ASSEMBLY

RELEASE)

COAT PER DART QSI 005 4.4 COAT PER DART QSI 018 UNLESS OTHERWISE NOTED RIC ABOUT CENTRE—LINES  $(\phi)$ WELD PER DART QSI 004 FINISH: POWDER COAT PE TOLERANCES ARE PER DAR PART IS SYMMETRIC ABOUT SHOP COPY RETURN TO ENGINEERING

CONTROLLED COPY WITHOUT NOTICE
WORK ORDER